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APPL-NO: JP06037648

APPL-DATE: February 10, 1994

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## ABSTRACT:

PURPOSE: To make unsealing easy while improving tightness in sealing for a bag made of a laminated body by a method wherein a dashed line for tearing-up provided to a position above a zipper is made in a specified structure.

CONSTITUTION: In a packaging body 1, seals 2 are provided to its periphery, a zipper 3 is provided transversely on the upper part of the bag and a dashed line 4 for tearing-up is provided to a position above the zipper 3. The bag 1 is constructed of a laminated body, a compound aluminum made at least of two layers, and the aluminum is desirable to be included in the inside layer in order to provide excellent airtightness to the bag 1. The dashed line 4 for tearing-up is formed at least to one layer on the outside of the layer constituting the laminated body, and is not formed to the inside layer formed at least of one layer. Thereby, a part above the zipper 3 can be cut easily while keeping airtightness for the bag, and contents in the package can be preserved stably.

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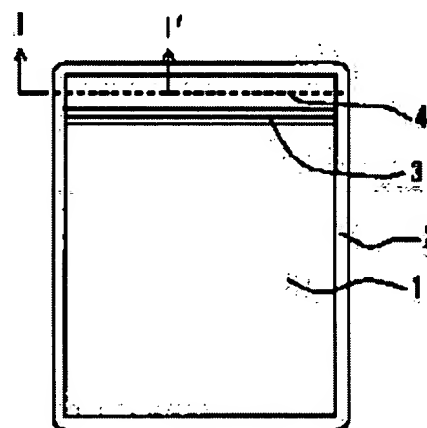
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### (54) BAG FOR PACKING

#### (57)Abstract:

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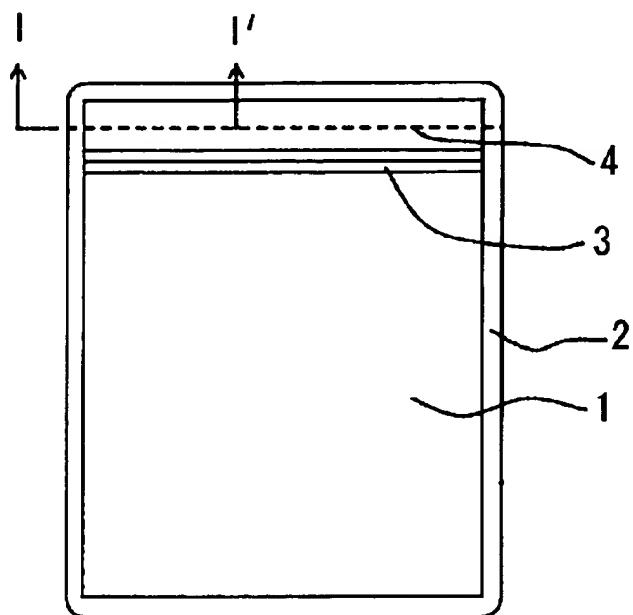
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DETAILED DESCRIPTION

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[Detailed Description of the Invention]

[0001]

[Industrial Application] This invention relates to the bag body for a package. When it says in more detail, this invention relates to the bag body for a package which consists of a layered product which has the broken line for \*\*\*\* which has a zip and a specific configuration.

[0002]

[Description of the Prior Art] In order to prepare a zip above a bag body in order to open and close the bag body for a package, and still to enable closing motion of the zip, forming a perforation-like broken line above a zip is known conventionally (JP,4-23796,Y etc.). If such processing is performed above a zip, since cutters, such as scissors, become unnecessary at opening of a bag body and it can open linearly with a finger, the appearance after cutting is good and an advantage, such as not damaging a zip part, is acquired. However, when a perforation is prepared in a bag body, the airtightness of a bag body is not maintained but there is a problem of it becoming impossible to secure the shelf life of package contents and stability. Package contents especially Drugs; Cairo; dried bonito flakes, such as fomentations and plaster, Fine particles, such as food; wheat, such as dried food; food boiled down in soy, such as a live knot, noodles, and seaweed, and pickles, and starch; Green tea, Luxury goods, such as coffee and tea; in being toiletries products, such as chemical; cosmetics; aromatics, such as chemical fertilizer and a spice, and a shampoo, etc. Since contents dry, generate heat, moisture will be included, a smell will leak to the bag body exterior, a volatile component will volatilize, or a component will deteriorate and deterioration of commodity value will be brought about, it is not desirable.

[0003]

[Problem(s) to be Solved by the Invention] Then, this invention is easy to open, and, moreover, it excels in sealing nature, and aims at offering the bag body for a package which can maintain the shelf life and stability of package contents.

[0004]

[Means for Solving the Problem] this invention persons completed a header and this invention for the ability of the above-mentioned purpose to be attained in the bag body which consists of a layered product by considering the broken line for \*\*\*\* formed above the zip as a specific configuration. Namely, have a seal to a perimeter, a zip is prepared crosswise in it in an upper part part, and this invention is set to the bag body for a package which consists of a layered product by which the broken line for \*\*\*\* was formed above said zip in parallel with said zip further. Said broken line for \*\*\*\* is formed in at least one layer of the outside which

constitutes said layered product, and becomes the inside layer which consists of at least one layer from said bag body for a package characterized by not being formed.

[0005]

[Function] By consisting of the above configurations, the bag body for a package of this invention can cut the upper part part of a zip easily, and moreover can maintain the airtightness of a bag body, therefore can secure the shelf life and stability of package contents, and can prevent that the smell of package contents leaks to the exterior of a bag body. Moreover, since the broken line for \*\*\*\* of the bag body for a package of this invention is not conspicuous on an appearance from the usual perforation, the fine sight of a bag body is not spoiled.

[0006]

[Example] Hereafter, this invention is explained in detail, referring to a drawing. Drawing 1 is the front view of the bag body for a package of this invention. As shown in drawing 1, a seal 2 is given to a perimeter, a zip 3 is formed crosswise [ of a bag body ] up, and, as for the bag body 1 for a package of this invention, the broken line 4 for \*\*\*\* is formed above the zip 3. The goods packed by the bag body packed by the bag body of this invention Especially although not limited especially, drugs; Cairo; instant noodles, such as fomentations and plaster, \*\*\*\* for spaghetti, the dried seaweed, an Undaria pinnatifida, a flower, or \*\* Dried food; food boiled down in soy, such as a live knot, Food, such as pickles; it can be used suitable for toiletries products, such as chemical; cosmetics; deodorants, such as luxury-goods; chemical fertilizer, such as fine-particles; green tea, such as base of a broth, wheat flour, katakuriko, and vegetables pickled in salted rice-bran paste, coffee, and tea, and agricultural chemicals, a shampoo, and a rinse, etc. Said bag body 1 for a package consists of layered products. Said layered product is a compound laminate film which consists of two-layer at least, and in order to excel the airtightness of a bag body, it is desirable that an aluminum layer is included in an inside layer. The layered product of this invention can be manufactured by any approaches of common use, such as a dry lamination process used for manufacture of a compound laminate film, the wet lamination nation method, a hot melt lamination process, and an extrusion lamination process.

[0007] The layer which constitutes said layered product becomes few from two-layer to be chosen from the film layer which consists of paper, a nonwoven fabric, cellophane, nylon, polyethylene, polyester, polypropylene, a polyvinyl chloride, an ionomer, a polyamide, a polyacrylonitrile, an olefin, a polyvinylidene chloride, polyvinyl alcohol, an ethylene-vinyl acetate copolymer, a polycarbonate, polystyrene, an ethylene-vinylalcohol copolymer, an ethylene acrylic copolymer, aluminum, etc. Especially the lamination of the layered product of this invention may be what kind of the compound laminate film which is not limited but is used for the usual bag body for a package of thing.

[0008] Hereafter, an example is given and the lamination of the layered product of this invention is explained. For example, when package contents are drugs, such as fomentations and plaster, the lamination of a layered product can consist of lamination, such as (1) paper / polyethylene-layer / aluminum layer / polyethylene layer, (2) cellophane layers / paper / polyethylene layer / aluminum layer / polyethylene layer, and (3) cellophane layers / polyethylene layer / paper / polyethylene layer / aluminum layer / polyethylene layer, toward an outside to the inside.

[0009] Moreover, when package contents are Cairo, the lamination of a layered product can consist of lamination, such as (4) polyethylene layers / polyvinylidene chloride / polypropylene

layer, (5) vinylidene-chloride coat polypropylene layer / polyethylene layer, and (6) vinylidene-chloride coat BINIDEN layer / polyethylene layer, toward an outside to the inside.

[0010] moreover, when package contents are dried bonito flakes The lamination of a layered product goes inside from an outside. For example, (7) polyvinylidene-chloride coat cellophane layer / polyethylene layer, (8) A polyvinylidene chloride coat cellophane layer / biaxial-stretching polypropylene layer / polyvinylidene chloride layer / polyethylene layer, (9) A biaxial-stretching polypropylene layer / polyvinyl alcohol layer / polyethylene layer, (10) A biaxial-stretching polypropylene layer / ethylene-vinyl acetate copolymer layer / polyethylene layer, (11) It can consist of lamination, such as a polypropylene layer / polyethylene layer, and (12) biaxial-stretching polypropylene layer / polyvinylidene chloride layer / polyethylene layer / polyvinylidene chloride layer / polyethylene layer.

[0011] Moreover, when package contents are instant noodles, spaghetti, a dried seaweed, an Undaria pinnatifida, etc., the lamination of a layered product can consist of lamination, such as (13) biaxial-stretching polypropylene layer / polyethylene layer, and (14) biaxial-stretching polypropylene layer / non-extended polypropylene layer, toward an outside to the inside. Moreover, when package contents are food, such as food boiled down in soy The lamination of a layered product goes inside from an outside. For example, (15) biaxial-stretching polypropylene layer / polyethylene layer, (16) A nylon layer / polyethylene layer, (17) polyvinylidene-chloride coat cellophane layer / polyethylene layer, (18) A biaxial-stretching polypropylene layer / polyvinylidene chloride layer / polyethylene layer, (19) A biaxial-stretching polypropylene layer / polypropylene layer / polyethylene layer, (20) It can consist of lamination, such as a biaxial-stretching polypropylene layer / polyvinyl alcohol layer / polyethylene layer, and (21) biaxial-stretching polypropylene layer / polyethylene layer / polyvinyl alcohol layer / polyethylene layer.

[0012] When package contents are pickles, moreover, the lamination of a layered product It goes inside from an outside. For example, (22) nylon layers / polyethylene layer, (23) A polyester layer / polyethylene layer, (24) polyvinylidene-chloride coat cellophane layer / polyethylene layer, (25) A biaxial-stretching polypropylene layer / polyvinylidene chloride coat cellophane layer / polyethylene layer, (26) A biaxial-stretching polypropylene layer / polyvinylidene chloride layer / polyethylene layer, (27) It can consist of lamination, such as a nylon layer / polyvinylidene chloride layer / polyethylene layer, (28) polyester layers / polyvinylidene chloride layer / polyethylene layer, and (29) biaxial-stretching polypropylene layer / polypropylene layer / polyethylene layer.

[0013] Moreover, when package contents are fine particles, such as base of a broth, and wheat flour, the lamination of a layered product can consist of lamination, such as (30) polypropylene layers / polyethylene layer / aluminum layer / polyethylene layer, and (31) polypropylene layers / polyethylene layer (/non-extended polypropylene layer), toward an outside to the inside.

[0014] When package contents are green tea, moreover, the lamination of a layered product It goes inside from an outside. For example, (32) polyvinylidene-chloride coat cellophane layer / polyethylene layer, (33) A biaxial-stretching polypropylene layer / polyvinylidene chloride coat cellophane layer / polyethylene layer, (34) A polyethylene layer / polyvinylidene chloride layer / polyethylene layer, (35) A biaxial-stretching polypropylene layer / polyvinylidene chloride layer / polyethylene layer, (36) -- biaxial-stretching polypropylene -- a layer / polyvinylidene chloride layer / polyethylene layer / non-extended polypropylene layer, (37) polypropylene layers / aluminum layer / polyethylene layer, (38) biaxial-stretching

polypropylene layer / aluminum layer / polyethylene layer, and [0015] (39) A polypropylene layer / polyethylene layer / paper / aluminum layer / polyethylene layer, (40) A polypropylene layer / polyethylene layer / paper / polyethylene layer (41) extension nylon layer / polyester layer / vacuum-plating-of-aluminium film layer / polyethylene layer, (42) Paper / polyvinylidene chloride layer / biaxial-stretching polypropylene layer / vacuum-plating-of-aluminium film layer / polyethylene layer, (43) It can consist of lamination, such as paper / polyester layer / vacuum-plating-of-aluminium film layer / polyethylene layer (44) moisture-proof-cellophane layer / aluminum layer / paper / polyethylene layer, and (45) moisture-proof-cellophane layers / polyethylene layer / non-extended polypropylene layer.

[0016] Moreover, when package contents are coffee and luxury goods like tea, the lamination of a layered product can consist of lamination, such as (46) polyester layers / aluminum layer / polyethylene layer, and (47) moisture-proof-cellophane layers / polyethylene layer / anidian extension polypropylene layer, toward an outside to the inside.

[0017] Moreover, when package contents are cosmetics, a chemical, and a toiletries product, the lamination of a layered product can consist of lamination, such as (48) polyester layers / anidian extension polypropylene layer, and (49) polyester layers / aluminum layer / polyethylene layer, toward an outside to the inside. These package contents are contained inside [ 11 ] the bag body of this invention which consists of a layered product.

[0018] About 50-300 micrometers, although especially the thickness of the whole layered product has desirable about 70-150 micrometers, it is not limited to this. Although the thickness of each class which constitutes a layered product is not limited to this, either, for example, with the above-mentioned configuration of (2) Especially 10-100 micrometers of cellophane layers 15-50 micrometers, 20-200 micrometers of paper, Especially, it is [ 50-100 micrometers, 10-100 micrometers of polyethylene layers, 10-30 micrometers, and 4-30 micrometers of aluminum layers ] 20-50 micrometers especially about 7-10 micrometers and 10-100 micrometers of polyethylene layers.

[0019] The broken line for \*\*\*\* is formed in at least one of the layers which constitute said layered product of an outside, and is not formed in the inside layer which consists of at least one layer. Although it is not limited, if an aluminum layer is contained in an inside layer, since especially the configuration of the layer of the inside in which the layer and broken line of the outside in which the broken line for \*\*\*\* is formed are not formed can maintain the airtightness of a bag body at altitude, it is desirable. Drawing 2 is a sectional view in alignment with I-I' of drawing 1, and shows the configuration of the layered product of the above (1). Although a part for the slot 5 which constitutes the broken line for \*\*\*\* will be formed in outside paper 7 and the outside polyethylene layer 8 if it explains with reference to drawing 2, a part for this slot 5 is not given to the aluminum layer 9 and the inside polyethylene layer 10. Moreover, with the configuration of the above (2), although the broken line for \*\*\*\* is formed in a cellophane layer, paper, and a polyethylene layer, the amount of slot has not reached an aluminum layer and a polyethylene layer. Moreover, with the configuration of the above (3), although the broken line for \*\*\*\* is formed, the amount of slot has not given a cellophane layer, a polyethylene layer, paper, and a polyethylene layer to the aluminum layer and polyethylene layer inside it.

[0020] If few force is applied to the edge of a broken line in spite of giving the broken line to a part of layered product according to the broken line for \*\*\*\* of this invention, it is torn along with a broken line and can cut linearly. Therefore, the appearance of the bag body after cutting depended for tearing is good, without scraps falling. tearing -- the part of a zip is not



damaged Especially, when package contents are drugs like pasting pharmaceutical preparation, since it is those to whom a user has the injured and muscular pain, such as elderly people and a bruise, in many cases, closing motion of a bag body becomes easy and is convenient.

[0021] In addition, even if this broken line 4 for \*\*\*\* is formed in the field of both bag bodys for a package of this invention, it may be formed in field of one of the two, and even if formed only in field of one of the two, it can be easily cut along with the broken line for \*\*\*\*.

Although the depth for the slot which constitutes the broken line 4 for \*\*\*\* formed in a layered product is not limited to these, 70-90 micrometers, it is desirable especially that it is 75-85 micrometers, and if the thickness of a layered product is about 70 - 80% 60 to 90%, since the force for tearing is also seldom needed and a broken line moreover is not conspicuous, it is desirable [ especially the depth. for a slot ]. As for especially the die length for a slot 5 of 1 which meets crosswise [ of a bag body ], it is desirable that it is 2-3mm 1-6mm. Moreover, as for especially the distance of between for adjoining slot [ part / for the slot of 1 ] 6, it is desirable that it is 1-3mm 1-6mm. Furthermore, being referred to as 1:1-5:1 is desirable, the ratio (the die length for the inside of drawing 2 and a slot 5: ratio of the die length of spacing 6) of the die length for the slot which meets crosswise [ of a bag body ], and the distance between adjoining slot parts is easy to \*\*\*\*\* especially when it is 2:1-4:1 especially, and since it moreover is not automatically torn during transportation, it is desirable.

[0022] The formation approach of the broken line for \*\*\*\* of this invention may be which approach. For example, the layered product of this invention can be manufactured by manufacturing the layer of the outside which consists of at least one layer in which the broken line for \*\*\*\* is formed, forming the broken line for \*\*\*\* in those layers, and sticking with the inside layer which consists of at least one layer in which a \*\*\*\* broken line subsequently is not formed. Moreover, if the layered product which contains an aluminum layer first is manufactured and laser light is irradiated after that on the outside of a layered product, since the broken line for \*\*\*\* is not formed in the layer below an ARUMINIMU layer since laser light is reflected, but a broken line is formed only in the layer above an aluminum layer, the aluminum layer is convenient.

[0023] Moreover, since the location of a broken line will become intelligible also for a dark location and a user with weak eyesight and it will become possible to tear by the still weaker force if the infeed section 12 is formed in the edge of the broken line 4 for \*\*\*\* as shown in drawing 3 , it is desirable. The infeed section 12 may be formed in the edge of one of the two of the broken line 4 for \*\*\*\*, or both, and can also be made into the thing of which configurations, such as V characters, U characters, and S etc. characters.

[0024] In addition, in the bag body of this invention, the seal 2 prepared in the perimeter of a bag body is formed by approach like heat joining for sealing maintenance. All the corner sections of a seal 2 or the corner section of the two upper parts can be made roundish [ wore ]. It is desirable, without being able to prevent giving a blemish to a user's fingertip by making it roundish [ wore ], and a bag body giving a damage mutually by the corner section during goods transportation. Moreover, in the bag body of this invention, a zip 3 may say the thing of the occlusion implement which consists of an engagement projection and an engagement crevice and in which the restart close is possible, and may be the thing of which classes, such as a chuck, a slide fastener, and a zipper.

[0025]

[Effect of the Invention] As explained above, since the specific broken line for \*\*\*\* is formed on the zip, compared with the bag body by the conventional technique, the bag body for a package of this invention is excellent in sealing nature, and can maintain the shelf life and stability of package contents at altitude. Package contents especially Drugs; Cairo; instant noodles, such as fomentations and plaster, \*\*\*\* for spaghetti, the dried seaweed, an Undaria pinnatifida, a flower, or \*\* Dried food; food boiled down in soy, such as a live knot, Food, such as pickles; Fine-particles; green tea, such as base of a broth, wheat flour, katakuriko, and vegetables pickled in salted rice-bran paste, Luxury goods, such as coffee and tea; since volatilization of desiccation, generation of heat, moisture, and a component, the leak out of the bag body of a smell, component deterioration, etc. can be prevented when it is toiletries products, such as chemical; cosmetics; deodorants, such as chemical fertilizer and agricultural chemicals, a shampoo, and a rinse, etc., it is useful.

[0026] Moreover, since the broken line for \*\*\*\* formed in the bag body of this invention is not conspicuous on an appearance compared with the conventional perforation etc., it does not spoil the fine sight of a bag body. And in spite of forming the broken line for \*\*\*\* in a part of layered product, the appearance after cutting is good [ a bag body / the bag body for a package of this invention is easy to open and ], without being able to cut by tearing linearly along with the broken line for \*\*\*\* after that, and damaging a zip, if few force is applied to the edge of the broken line for \*\*\*\* with a finger. Since a bag body can be especially opened easily even if the users of a bag body are surgery patients, such as elderly people and a bruise, a person with weak eyesight, etc., it is convenient.

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DESCRIPTION OF DRAWINGS

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[Brief Description of the Drawings]

[Drawing 1] It is the front view of the bag body for a package of this invention.

[Drawing 2] It is a sectional view in alignment with I-I' of the bag body for a package of drawing 1 .

[Drawing 3] It is the front view showing other modes of the bag body for a package of this invention.

[Description of Notations]

1 Bag Body for Package

2 Seal

3 Zip

4 Broken Line for \*\*\*\*

5 A Part for Slot

6 Spacing for a Part for Slot, and Slot

7 Paper

8 Polyethylene Layer

9 Aluminum Layer

10 Polyethylene Layer

11 Interior of Bag Body

12 Infeed Section

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TECHNICAL PROBLEM

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[Problem(s) to be Solved by the Invention] Then, this invention is easy to open, and, moreover, it excels in sealing nature, and aims at offering the bag body for a package which can maintain the shelf life and stability of package contents.

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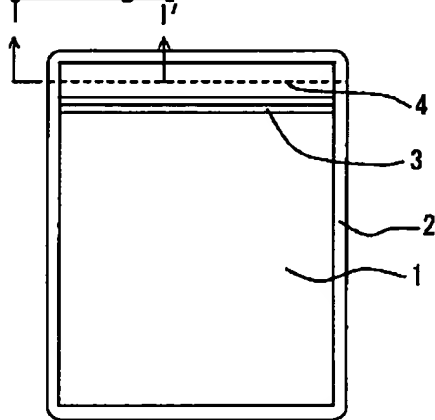
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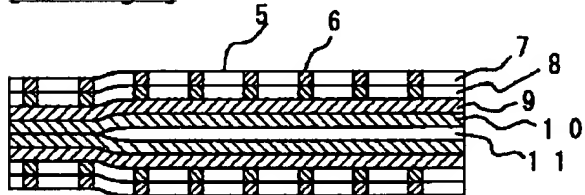
DRAWINGS

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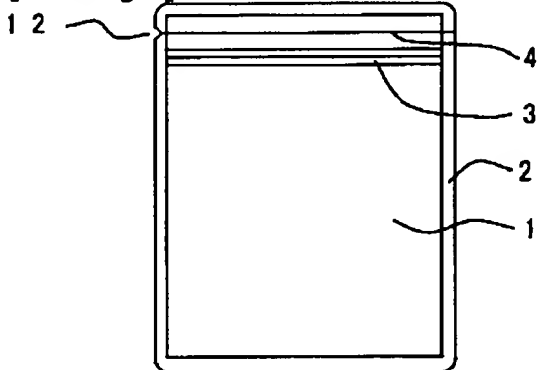
[Drawing 1]



[Drawing 2]



[Drawing 3]



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